

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005860**Date Inspected:** 27-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1830**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS tower**Summary of Items Observed:**

Bay #10 South and North Tower Shop

South Tower Lift #2:-Caltrans QA Inspector observed four ZPMC workers in process of grinding on fit lug welds. The grinding purpose is remove the weld profile which have been rejected by QC that exceeding AWS D1.5 code limitations. The fit lug welds located at elevation 53m to 80.75m on skin plate D and E. Based on Caltrans QA inspector observations, no discrepancies were noted.

South tower lift #1:- Caltrans QA inspector performed final VT and MT inspection on the fit lug welds and diaphragm welds of skin plate B and C. Those weld connected to fit lugs, diaphragm and skin plate. The fit lug welds and diaphragm welds located at elevation 9m, 13m, 15m, 18m, 23m, 28m, 33, 38, 43 and 47.6m. All the welds have been VT and MT accepted by ZPMC and ABF QC prior Caltrans QA inspection. Base on Caltrans inspection, the fit lug welds and diaphragm welds appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

Bay #11 East and West Tower Shop

East tower lift #2:- Caltrans QA inspector performed final VT inspection on the fit lug welds and diaphragm welds of skin plate B and C. Those weld connected to fit lugs, diaphragm and skin plate. The fit lug welds and diaphragm welds located at elevation 80.7m. All the welds have been VT accepted by ZPMC and ABF QC prior Caltrans QA inspection. Base on Caltrans inspection, the fit lug welds and diaphragm welds appeared to be in compliance with requirements of AWS D1.5 2002 and Caltrans contract documents.

East Tower Lift #2:-Caltrans QA Inspector observed three welders performed FCAW repair process on inner corner longitudinal seam weld that connected skin plate C and D. and the weld number is SSD1-A111B/H-124, 91 and 242. All the excavated weld areas have been MT test prior repair welding. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were

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noted.

Summary of Conversations:

As noted within the report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Pau, Wai	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
